

volving bonding drum apparatus 32 by means of a belt 134. The revolving bonding drum apparatus 32 in turn drives the endless belt 26. Those skilled in the art will appreciate the fact that by means of suitable adjustments to the transmission 126 to regulate the speed of operation of the revolving bonding drum assembly 32 and by means of concurrent adjustments to the operating power which is supplied to the heating band 96, the operating parameters of the system 10 may be varied in order to optimize the bonding of the strip of belt loop material 12 to the strip of interfacing material 18.

A completed bonded belt loop 140 fabricated by means of the present invention is illustrated in FIG. 5. Thus, in accordance with the present invention, the opposed edges of the strip of belt loop material 12 are adhesively secured to one side of the strip of interfacing material 18. However, the remainder of the adjacent surfaces of the strip of belt loop material 12 and the strip of interfacing material 18 are not adhesively secured one to the other. The folding apparatus 80 of the system 10 is so constructed that the opposed edges of the strip of belt loop material 12 are secured to the strip of interfacing material 18 in a spaced apart relationship. By this means there is prevented any overlapping of the edges of the belt loop material in the finished belt loop. Moreover, the trimming apparatus is so adjusted that the edges of the strip of belt loop material 12 extend beyond the edges of the strip of interfacing material 18. In actual practice such a belt loop has been found to be considerably more satisfactory than would be the case if the strip of belt loop material 12 were to be wrapped tightly around the strip of interfacing material 18.

Referring again to FIG. 1, each length of belt loop material 12 is positioned lengthwise on the support 14 and is advanced into engagement with the endless belt 16. It will be understood that the strip of belt loop material 12 may extend to any desired length, and may be fed from a supply reel if circumstances require. However, under more usual circumstances the strips of belt loop material 12 will comprise relatively short lengths of material which would otherwise be considered as scraps generated during the cutting of cloth for the manufacture of men's trousers and similar garments. For example, the strips of belt loop material 12 may have overall length as short as about 10 inches or less.

The strips of belt loop material are fed into the system sequentially and in an end-to-end relationship. It will be understood that the strip of interfacing material 18 is substantially continuous relative to the strips of belt loop material 12, and therefore serves to connect the strips of belt loop material 12 into a relatively long string which emerges from the revolving bonding drum apparatus 32 of the system 10 in the manner illustrated in FIG. 1 at 112. This string is then processed into individual belt loop segments by means of a belt loop trimming apparatus.

The individual belt loop segments are thereafter crimped in a belt loop crimping apparatus, after which the belt loop segments are attached to men's trousers or similar garments.

From the foregoing, it will be understood that the present invention comprises a system for making bonded belt loops which incorporates numerous advantages over the prior art. Thus, by means of the invention, belt loops are fabricated on a continuous basis, thereby eliminating the time-consuming and costly

manual operations which are required when belt loops are manufactured by the sewing process. Another advantage deriving from the use of the invention involves the fact that the bonded belt loops may be manufactured by means of the invention to any desired width and yet do not exhibit any tendency toward wrinkling or distortion as is often observed in the case of sewn belt loops of greater than conventional width. Still another advantage relates to the fact that substantially greater cloth utilization is realized by means of the invention.

Although particular embodiments of the invention have been illustrated in the accompanying Drawings and described in the foregoing Detailed Description, it will be understood that the invention is not limited to the embodiments disclosed, but is capable of numerous rearrangements, modifications, and substitutions of parts and elements without departing from the spirit of the invention.

What is claimed is:

1. A method of making bonded belt loops which comprises:

providing a strip of interfacing material having a thermally responsive layer formed on one side thereof;

engaging the reverse side of a strip of belt loop material with the side of the strip of interfacing material opposite from the adhesive layer;

folding the opposite edges of the strip of belt loop material around the strip of interfacing material;

heating the adhesive layer of the strip of interfacing material sufficiently to effect activation thereof;

pressing the opposed edges of the strip of belt loop material into engagement with the activated adhesive layer and thereby permanently bonding the strip of belt loop material to the strip of interfacing material;

said heating and pressing steps being carried out simultaneously by passing the strip of interfacing material having a belt loop material folded therearound between the periphery of a revolving heated drum and an endless belt traveling around a course including a portion coincident with the periphery of the drum; and

transporting both the strip of interfacing material and the strip of belt loop material on said endless belt through the folding step, and around the revolving heated drum.

2. The method of making bonded belt loops according to claim 1 including the additional step of trimming the strip of belt loop material to a width such that the edges of the strip of belt loop material extend beyond the edges of the strip of interfacing material in the finished belt loop.

3. The method of making bonded belt loops according to claim 1 wherein the folding step is further characterized by positioning the opposed edges of the strip of belt loop material in a spaced apart relationship and thereby preventing overlap of the edges of the strip of belt loop material in the finished belt loop.

4. A method of making bonded belt loops which comprises:

providing a strip of interfacing material having a layer comprising a thermally responsive adhesive material disposed on one side thereof;

trimming a strip of belt loop material to a predetermined width;